

Technical Data Sheet



ALCOM WP PA6 3230 BK1025-20

Base Polymer	Polyamide 6
Filler/Additive System	15 % glass beads,15 % glass fibres,2 % molybdenum disulphide
Special Features	improved sliding / wear,heat stabilised,easy flow,easy release (demoulding),fast solidifying
Typical Applications	injection moulded parts

Pre-Drying Conditions	80 °C in a dry air (dessiccant) dryer for 2-12 h dependant on moisture content max. moisture content <0,15 %
Processing Injection Moulding	melt temperature 270-290 °C mould temperature 80-100 °C
Storage	dry, protected from light

Properties	dry/cond.	Dimension	Test Norm
Mechanical Properties			
Flexural Modulus	6300 / 3500	MPa	ISO 178
Flexural Strength	195 / 115	MPa	ISO 178
Tensile Modulus	6700 / 3700	MPa	ISO 527
Tensile Strength at Break	120 / 75	MPa	ISO 527
Tensile Elongation at Break	2.9 / 10	%	ISO 527
Impact Strength (Charpy, 23°C)	37 / 85	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	35 / -	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	5.5 / 9	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	4.5 / -	kJ/m ²	ISO 179/1eA
Thermal Properties			
HDT / A (1,8 MPa)	205 / *	°C	ISO 75-1/-2
DSC (Melt Point)	220 / *	°C	ISO 11357
Rheological Properties			
Shrinkage (lengthwise, 24h)	0.3 - 0.5	%	ISO 294-4
Shrinkage (lateral, 24h)	0.7 - 0.9	%	ISO 294-4
Physical Properties			
Density	1380 / -	kg/m ³	ISO 1183